

Date: Friday, 09/05/2008 1:44:50 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L/L3/L4/407 LOW, 407 HIGH GEAR SKID	
Job Number :	39151	Part Number :	D206642312	
Estimate Number :	10552	Drawing Number :	N/A	
P.O. Number :		Project Number :	N/A	
This Issue :	09/05/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	L	
First Issue :	//	Type :	SKIDTUBES	
Previous Run :	39150	Material :		
Written By :		Due Date :	05/06/2008	Qty: 1 Um: Each
Checked & Approved By :	JLD 08.5.09			
Comment :	Est Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC Est Rev:K 07-12-04 ECN 1080p DD verified by:			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-312 CHG004

S 08/07/08 JLD 08.5.16

2.0	39151A	206 L HIGH GEAR SKIDTUBE
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Comment: Sub-Component 206L/407 LOW, 407 HIGH GEAR SKIDTUBE
 D206-642-341 B 39151A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	D206648011	GHW Modification
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 GHW Modification Kit
 Batch: 391176

39

5.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
 BUSHING
 Pick:

Qty	Part Number	Description	Batch
16	D2652	Bushing	38875
1	D206-642-341(REF)		39151A

8/5/30

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39151

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

TOW RING

Pick:

Qty	Part Number	Description
1	D2655	Tow Ring

Batch

34613

sp

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

SET SCREW

Pick:

Qty	Part Number	Description
10	D2712	Set Screw

Batch

37765

sp

8.0

D29322

Saddle RH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description
1	D2932-2	Saddle

Batch

B39772

AS 08/06/17 (N)

9.0

D29332

Saddle RH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SADDLE

Pick:

Qty	Part Number	Description
1	D2933-2	Saddle

Batch

39889

* New Batch

AS 08/07/02 (X)

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SADDLE SPACER

Pick:

Qty	Part Number	Description
2	D2934	Saddle Spacer

Batch

37368

FB/30

sp

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 39151

Part Number: D206642312

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	D2935	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SADDLE SPACER

Pick:

Qty	Part Number	Description	Batch
2	D2935	Saddle Spacer	57867

sd

12.0	D29382	Saddle RH Out, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2938-2	Saddle	39158

8/6/26

sp

13.0	D29392	Saddle RH In, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SADDLE

Pick:

Qty	Part Number	Description	Batch
1	D2939-2	Saddle	36144

sp

14.0	D2968043	Tow Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
TOW RING

Pick:

Qty	Part Number	Description	Batch
1	D2968-043	Tow Ring	37380

sp

15.0	AN341A	Bolt
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
BOLT

Pick:

Qty	Part Number	Description	Batch
8	AN3-41A	Bolt	107242

8/5/30

sp

Dart Aerospace Ltd

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Job Number: 39151

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

1 AN4-5A

Bolt

106605

SP

17.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

12 AN4-6A

Bolt

106662

SP

18.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4 AN5-10A

Bolt

107013

(or AN5-11A)

Choice of bolt will depend on crosstube

SP

19.0

AN511A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

4 AN5-11A

Bolt

105870

(or AN5-12A)

Choice of bolt will depend on crosstube

SP

20.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

108077

8/5/30

(K)

SP

W/O:		WORK ORDER CHANGES					
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Job Number: 39151

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
8	AN960JD10	Washer	<u>108077</u>

21.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
1	AN960JD1016	Washer	<u>559</u>

sq

22.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
25	AN960JD416	Washer	<u>103338</u>

sq

23.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
8	AN960JD516	Washer	<u>107534</u>

sq

24.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	<u>107715</u>

8/5/30

sq

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 39151

Part Number: D206642312

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description
8	MS21042L3	Nut

Batch

107644

26.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

NUT

Pick:

Qty	Part Number	Description
13	MS21042L4	Nut

Batch

106051

8/3/30

sf

(1x)

sf

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

08/07/02 (2)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-312

Location:

PPP Rev:

08/1/2 (1)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/03

Job Completion



mf 08-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes

Item	Qty -311	Qty -312	Qty -341	Qty -343	Qty -011	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-343	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO: 39151

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Revision: L
Date: 07.10.25

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